

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028817**Date Inspected:** 04-Dec-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

<b>CWI Name:</b>	Andrew Keech and Jesse Cayabyab			<b>CWI Present:</b>	Yes	No
<b>Inspected CWI report:</b>	Yes	No	N/A	<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Electrode to specification:</b>	Yes	No	N/A	<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Qualified Welders:</b>	Yes	No	N/A	<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved Drawings:</b>	Yes	No	N/A	<b>Approved WPS:</b>	Yes	No N/A
				<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Bridge No:</b>	34-0006			<b>Component:</b>	SAS Tower	

**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At Tower Base Electro Slag Weld (ESW) 'G' weld joint #S-045 face A, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at locations Y=2000, Y=2090, Y=2100 and Y=2210mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation from 26mm deep where they left off Monday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Jesse Cayabyab was observed performing Magnetic Particle Testing (MT) on the following various depths with no significant indication noted so far. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 32mm with no indication noted. The shift was completed up to this depth of excavation.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

1. 27mm in depth – no significant indication noted.
2. 28mm in depth – no significant indication noted.
3. 29mm in depth – no significant indication noted.
4. 30mm in depth – no significant indication noted.
5. 31mm in depth – no significant indication noted.

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6. 32mm in depth – no significant indication noted.

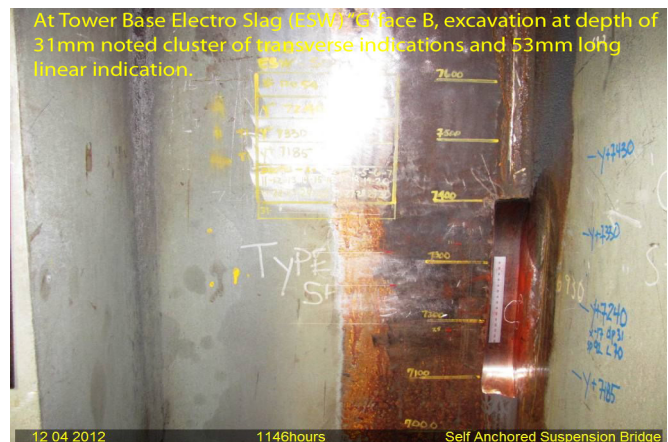
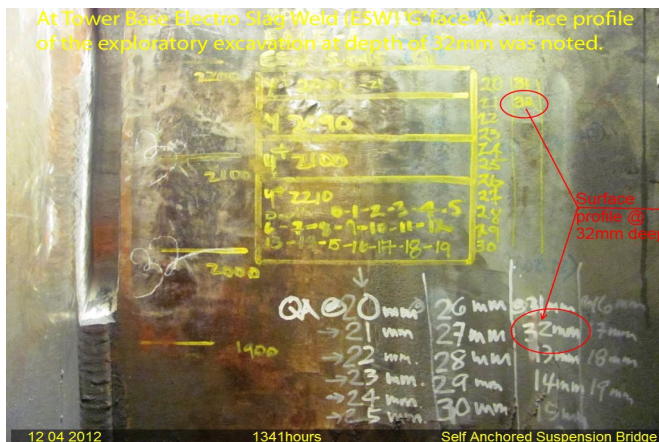
The exploratory excavations at this location will be continued on the following shift.

At Tower Base Electro Slag Weld (ESW) 'G' weld joint #S-045 face B, ABF personnel was observed continuing to perform exploratory excavation on welded ESW at locations Y=7185mm, Y=7040mm and Y=7330mm due to UT detected defects. The ABF personnel have resumed the exploratory excavation from 28mm deep where they left off Monday. The personnel were noted using only the disc grinder in every 1mm increments of excavation. ABF QC Andrew Keech was observed performing Magnetic Particle Testing (MT) on the following various depths with noted indications. This QA also performed the same test and noted same result. During the shift, the ABF personnel continued the excavation in 1mm increments using the same method of test and verification up to 33mm with noted result mentioned below. The shift was completed up to this depth of excavation.

The starting depth of excavation on this date was a continuation from the previous shift. The results of the exploratory excavations are as follows;

1. 29mm in depth – one 52mm linear, one 5mm and one 3mm transverse indications noted.
2. 30mm in depth –one 53mm long linear and around seven 2-3mm long transverse indications noted.
3. 31mm in depth –one 50mm long linear and around seven 2-3mm long transverse indications noted.
4. 32mm in depth – one 50mm long linear and around five 2-3mm long transverse indications noted.
5. 33mm in depth – one 50mm long linear, and around three 2-3mm long transverse indications noted.

The exploratory excavations at this location will be continued on the following shift.



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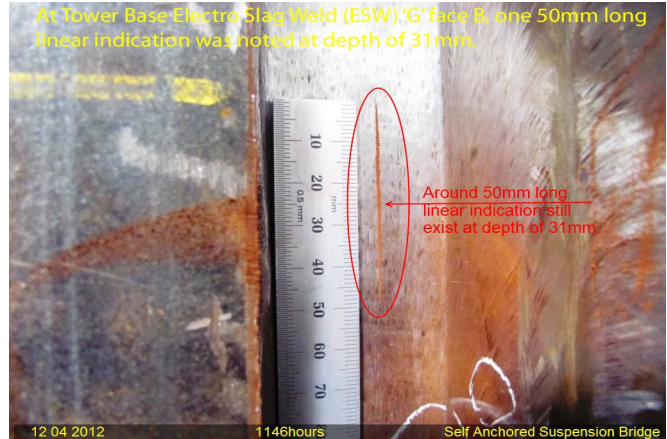
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At Tower Base Electro Slag Weld (ESW) 'G' face B, cluster of transverse indications was also noted at depth of 31mm.



At Tower Base Electro Slag Weld (ESW) 'G' face B, one 50mm long linear indication was noted at depth of 31mm.



## Summary of Conversations:

No significant conversation today.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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**Inspected By:** Lizardo, Joselito

Quality Assurance Inspector

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**Reviewed By:** Reyes, Danny

QA Reviewer